Quality Control

Work Order ID 71863 Wednesday, July 13, 2011 11:01:43 AM								?				Page 1
Revision ID:	D3492-11			A	Accept				S	etup Sta		
	Plug 7/14/2011 7/28/2011	Start Qty: 20.00 Req'd Qty: 20.00				Cust Item II Customer:	D:				1111111111	
Approvals:	Process Pla	an: MF	Date: 1	-07-13	Tooling:	Da	te:		P	Run Sta		
	QC:		Date:		SPC (Y/N):		te:			Sto	P	
Sequence ID/ Work Center ID	- 	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr	١					,		- 10 0		
D3492	D											
100 Hardinge		Hardinge CNC LATHE	SMALL		0.00			{	20	Ø		
Hardinge CNC Lathe	Small	I-Turn as pe Dwg Rev: Folio Rev:	er Folio FA714	& Dwg D349	11/4/26							
1103 OC		QC2- Inspect parts off m	achine FAI/FA	IB	0.00				20	b		
Quality Control		Memo	7	1	11) 4/2	6				, ,		
120		QC8- Inspect parts - seco	ond check		0.00	11.7-2	E		20	f		
QC		Memo			0.00							

Dait Ac	ospace	Liu							
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROC	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									:
	,								
Part No	:	PAR #:	Fault Cated	orv:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE (NCI	₹)			
DATE	OTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Chief Eng	QC Inspector
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		•							
		-							

Page 2

Item ID:

D3492-11

Wednesday, July 13, 2011 11:01:43 AM

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Plug

7/14/2011

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Required Date: 7/28/2011

Process Plan:

Date: _____

Tooling:

Date: ____

Tool # Plan

Code

Run

Start

Stop



Date:

SPC (Y/N):

Date:

Stop

Reject

Otv

Number Stamp

Insp.

Sequence ID/ Work Center ID

150

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

0.00

Accept

Qty

20 BK 11-7-26.

Reject

160 Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum \

MU7745. Memo

Memo

START TIME:

FINISH TIME:

0.00

0.00

(Flat End Only)

OVEN TEMPERATURE

0.00

Quality Control

170

QC3- Inspect Part Finish

Memo

0.00

20 d Multal27

	- oppass									
W/O:			V	ORK ORDER CHANG	GES	_	• •			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			·							
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Y	es N	o DQ	A:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Clos	ed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			ction B		Verific	cation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sig	gn & ate	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 71863

Wednesday, July 13, 2011 11:01:43 AM



Page 3

Item ID:

D3492-11

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Plug

Required Date: 7/28/2011

7/14/2011

QC:

Start Qty: 20.00

Req'd Qty: 20.00

Operation

Description



Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Run

Start

Stop

Sequence ID/

Work Center ID

180

Packaging

Packaging

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan

Date:

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

190

QC

Quality Control

QC21- Final Inspection - Work Order Release :

Identify as per dwg & Stock Location PR

0.00

0.00

W/O:			W	ORK ORDER CHANG	ES		-1-1-11			
DATE	STEP	PROC	EDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		:						-		
Part No	:	PAR #:	_ Fault Cate	gory:	NCR: Y	es N	o DQ	A:	_ Date: _	
	R	esolution:	_ Dispositio	n:	_ QA: N/C	Clos	sed:		Date: _	
NCR:		We	ORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, July 13, 2011 11:01:40 AM

Work Order ID: 71863

Parent Item:

D3492-11

Parent Item Name: Plug



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.875		Purchased	No			100	f	10.6000	0.04	0.842105			
										- V	1//	1/	2

6061-T6 Round Bar .875"

Location Loc Qty Loc Code 10.6 10.6

4.64

	P	· —···							
W/O:			W	ORK ORDER CHANG	iES			, , , , , , , , , , , , , , , , , , ,	
DATE	STEP	PRO	DCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							•		
							·		
Part No	•	PAR #:	Fault Cat	tegory:	NCR: Ye	s No [DQA:	Date: _	
	R	esolution:	Dispositi	ion:	_ QA: N/C	Closed:		Date: _	
NCR:		·	WORK ORI	DER NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC			ion B	Vei	rification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		Section C	Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	71863
Description: Plug	Part Number:	D3492-11
Inspection Dwg: D3492 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.850	+0.010/-0.001	.857			51-9	
Ø0.664	+0.008/-0.001	664			/	
0.045	+0.000/-0.002	-044				
0.090	+0.000/-0.002	.090				
0.500	+/-0.010	-500			1	
0.060	+/-0.005	061				
0.060	+/-0.005	060				
0.050 x 20°	+/-0.010 x 0.5°	-033XJ2P				
					· i	

Measured by:	51	Audited by:	Rep	Preliminary Approval:	
Date:	11)7/26	Date:	11.7.25	Date:	

Rev	Date	Change		Revised b	v	Approved
_ A	08.02.28	New Issue	P/O D3492-049	KJ/DD //	^	
В	11.06.21	Dwg Rev updated		KJ K	* /	
					/ 	

	Johnson								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			• •						
									
									,
						•].
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	:	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	R)			
DATE	STEP	Description of NC	ļ		tion B	Verific	cation	Approval	Approval
DAIL	JIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		on C	Chief Eng	QC Inspector
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		,							
									- 5 .
l									

D3492-XX PLUG (SEE TABLE)--NAS1611 O-RING (SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
-						Х	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	-1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					_ 1		D3492-11	PLUG
						_1	D3492-13	PLUG
		1					NAS1611-005	O-RING
1			1_				NAS1611-007	O-RING
1							NAS1611-010	O-RING
				[1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1		-	NAS1611-016	O-RING

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

#71863

DESIG	N			
REV.	DESCR	IPTION	84	DATE
Α	NEW IS	SUE	PH	06.01.04
В	ADD -04	7; UPDATE DIM A F	PH	06.05.11
С		49/-051/-053, CHANG	PH	07.10.05
D	WAS 0.	PORATED DEO D349 055. (SEE CAR11-04	AJS	11.05.24

DESIGN	PH	DART AEROSPACE LTD					
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECKED	k	DRAWING NO.	REV. D				
MFG. APPR.	JEL	D3492	SHEET 1 OF 2				
APPROVED	VA	TITLE	SCALE				
DE APPR.	7	PLUG	2:1				
DATE 11	15 24	COPYRIGHT © 2007 BY DART AEROSPACE LTD					

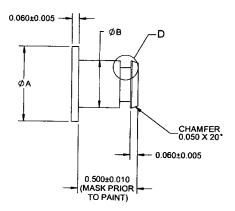
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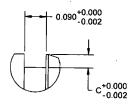
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W/O:			WO	RK ORDER CHANGE	ES					
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:			Fault Categ	NCR:	Yes N	o DQ/	A :	Date:		
Resolution:			Disposition: QA			A: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE ((NCR)				,
DATE	CTED	Description of NC	Corrective Action Section B			Verificat		ation	n Approval	Approval
DATE STEP		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector

POWDER COAT THESE FACES ONLY PER NOTE 2





DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

Ī.,	MATERIAL SPEC	С	В	Α	P/N
<u>-</u> 6	M6061T6R0.625	0.050	0.394	0.625	D3492-1
1 2	M6061T6R0.750	0.045	0.582	0.750	D3492-3
1	M6061T6R0.375	0.045	0.188	0.375	D3492-5
1	M6061T6R0.500	0.045	0.270	0.500	D3492-7
1	M6061T6R1.000	0.045	0.750	0.938	D3492-9
†·	M6061T6R0.875	0.045	0.664	0.850	D3492-11
<u> </u>	M6061T6R0.750	0.045	0.510	0.750	D3492-13

#71863

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061 f6R0.000)
2) FINISH: CHÉMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

6

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. D D3492 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE DE APPR. **PLUG** 4:1 DATE 11.05.24

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								·			
Part No	:	PAR #:	Fault Category: NO			ICR: Yes No DQA: Date:					
Resolution:			Disposition: QA			QA: N/C Closed: Da					
NCR: WORK ORDER NON-CONFORMANCE (NCR)											
DATE	STEP	Description of NC Section A	Corrective Action Section B		n B	Cian 0	Verificatio		Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector	
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